

De-Rev 54428

# Work Order ID 53842



November 19, 2009 11:28:03 AM

Item ID:	D3650-3	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Center Panel					
Start Date:	19/11/2009	Start Qty: 10.00		Cust Item ID:		
Required Date:	25/11/2009	Req'd Qty: 10.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-11-19	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3650	Rev C								

100  
 FLOW WATER JET 0.00  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D3650 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
 Deburr if necessary

IB 9-11-23

(12)

110  
 QC2- Inspect parts off machine FAI/FAIB 0.00  
 QC Memo 0.00  
 Quality Control

IB 9-11-23

120  
 QC8- Inspect parts - second check 0.00  
 QC Memo 0.00  
 Quality Control

⇒ 8 or 1/123

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<del>2/1/2012</del>								

**NOTE:** Date & initial all entries

# Work Order ID 53842

November 19, 2009 11:28:03 AM



Page 2

Item ID:	D3650-3	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Center Panel					
Start Date:	19/11/2009	Start Qty: 10.00		Cust Item ID:		
Required Date:	25/11/2009	Req'd Qty: 10.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130	NC BRAKE	0.00				<u>10</u>			<u>20</u>
	Brake NC	Memo	0.00						
	Brake NC	1-Form as per Dwg D3650 using DT9426□2-bend as per dwg							

140	QC5- Inspect part completeness to step on W/O	0.00				<u>11</u>	<u>1</u>		
	QC	Memo	0.00						
	Quality Control								

150	Identify as per dwg & Stock Location: <u>WAC25A</u>	0.00				<u>11</u>			<u>20</u>
	Packaging	Memo	0.00						
	Packaging								

N/A

09.12.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-3 PAR #: \_\_\_\_\_ Fault Category: Small Pbs NCR: (Yes) No DQA: \_\_\_\_\_ Date: 03.12.11  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 05.12.11

NCR: 53842		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/12/02	130	center panel 1 part is scrap form on wrong side Section J-J. R-C human error LOA.	<i>[Signature]</i>	destroy Scrap no replace	<i>[Signature]</i> 09/12/02	S 09/12/02	<i>[Signature]</i>	<i>[Signature]</i> 05/12/02

NOTE: Date & initial all entries

# Work Order ID 53842

November 19, 2009 11:28:03 AM



Page 3

Item ID: D3650-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Center Panel

Start Date: 19/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 25/11/2009 Req d Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-trim to fit (D3650-11)□2-Weld assembly as per dwg D3650 QSI004□3-grind weld smooth if necessary

*Handwritten signature and date: 11/20/09*

170



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

*Handwritten: D 09.12.08 (11)*

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*Handwritten: => Serial 1208*

*Handwritten: (AW)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53842**

November 19, 2009 11:28:03 AM



Page 4

Item ID: D3650-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Center Panel

Start Date: 19/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: 189

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Rec'd 12/10 (12)09/12/10 kgh 09/12/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November 19, 2009 11:28:10 AM

Page 1

Work Order ID: 53842

Parent Item: D3650-3RevC

Parent Item Name: Center Panel


Comments:

Start Date: 19/11/2009

Required Date: 25/11/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S26GA  304/316 0.018 SHEET		Purchased	No			160	sf	186.0064	12.0526	15.		

189-11-23

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	186.0064	
105591	0.39	
107021	1.21	
108415	3.19	
109398	85.2164	
112885	96	

12

109398

D3650-11 Qty 1 batch: 345721 → (11) # 09/12/09

R 09.12.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53842
<b>Description:</b> Center Panel		<b>Part Number:</b> D3650-3
<b>Inspection Dwg:</b> D3650	<b>Rev:</b> B	<b>Page</b> 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.221	+0.005/-0.001	.221	✓			
Ø0.213	+0.005/-0.001	.215	✓			
0.40	+/-0.030	.403	✓			
15.45	+/-0.030	15.45	✓			
10.49	+/-0.030	10.49	✓			
15.53	+/-0.030	15.53	✓			
11.99	+/-0.030	11.99	✓			
12.90	+/-0.030	12.90	✓			
4.300	+/-0.010	4.299	✓			
12.09	+/-0.030	12.09	✓			
13.06	+/-0.030	13.06	✓			
1.943	+/-0.010	1.943	✓			
5.884	+/-0.010	5.884	✓			
8.248	+/-0.010	8.249	✓			
9.196	+/-0.010	9.199	✓			
13.80	+/-0.030	13.80	✓			
2.28	+/-0.030	2.275	✓			
7.19	+/-0.030	7.188	✓			
9.55	+/-0.030	9.547	✓			
10.65	+/-0.030	10.645	✓			
3.35	+/-0.030	3.355	✓			

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-11-23	<b>Date:</b> 09/11/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	JB

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AIRCRAFT

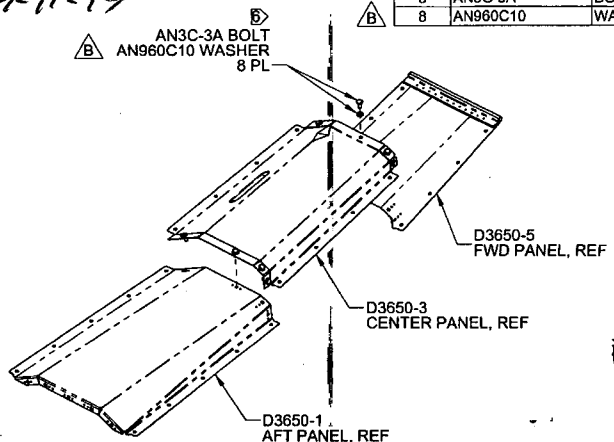
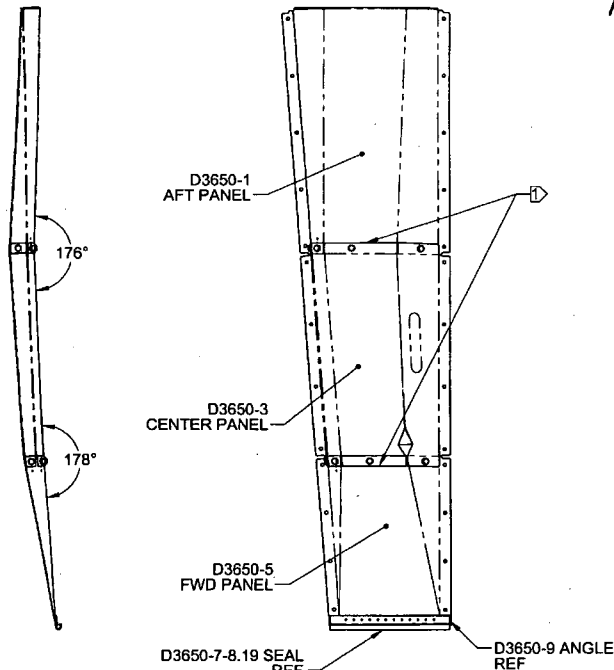
WITHOUT THE

WORK ORDER

NO. 53842

3109-11-19

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



DEO ATTACHED

UNDER REVIEW  
OK 07.05.08  
BAR 05.04.08  
RELEASE  
OK 11.17.08

D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-8, D5-6); MS20615-4MS WAS CR3523-4-03 & NAS1149CN432R WAS AN960C4 (ZN D5-7; B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOFF TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.14		

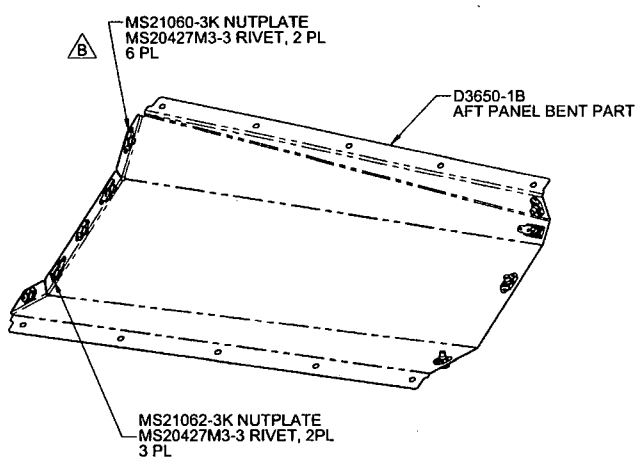
DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3650  
REV. C  
SHEET 1 OF 9

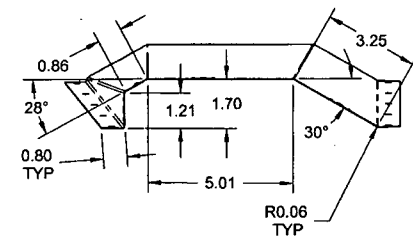
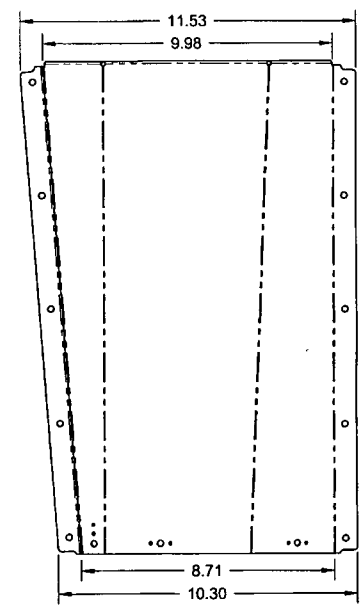
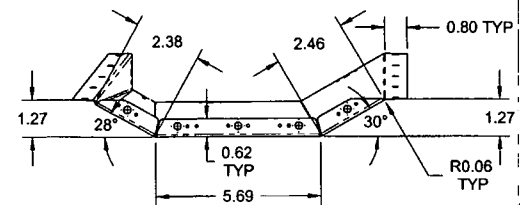
TITLE TOP PANEL ASSEMBLY  
SCALE 1:8

COPYRIGHT © 2007 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

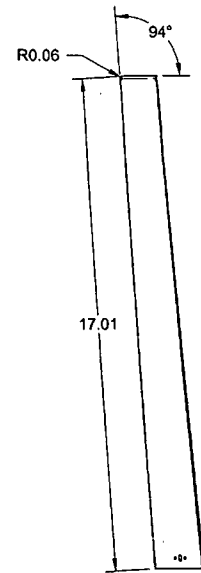
8 7 6 5 4 3 2 1



**D3650-1 AFT PANEL**



QTY	PART NUMBER	DESCRIPTION
-1		
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



DEO ATTACHED

UNDER REVIEW *OK 09/22/03 P. 09/22/03*

RELEASED *04/11/07 MP*

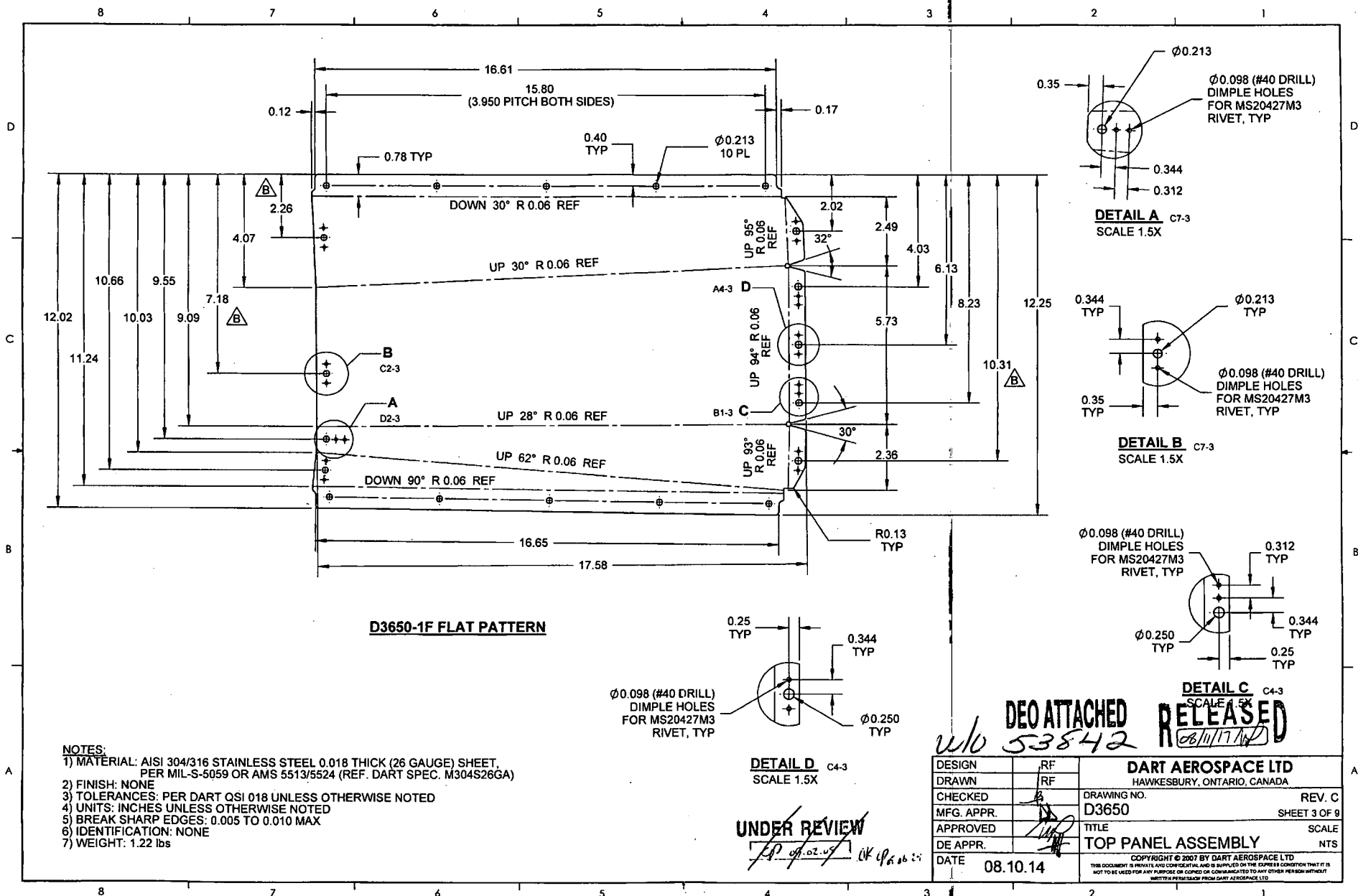
**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)

*W/0 53842*

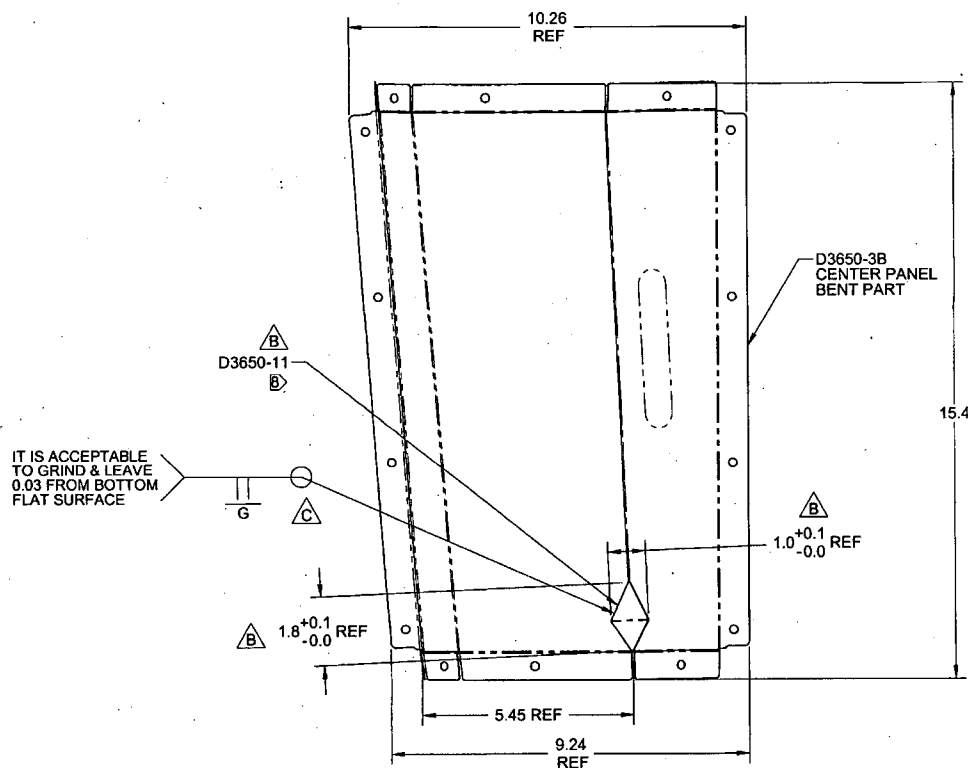
- NOTES:
- 1) FINISH: NONE
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) WEIGHT: 1.3 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

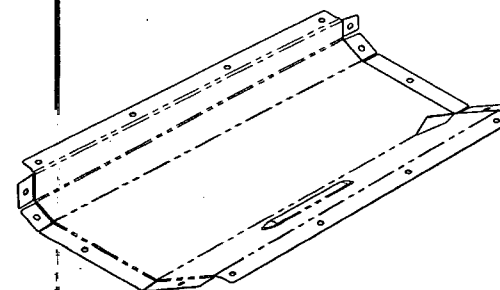
8 7 6 5 4 3 2 1



QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE



**D3650-3 CENTER PANEL**  
(LOOKING FROM OUT SIDE SURFACE)



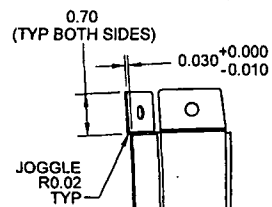
- NOTES:
- 1) WELD PER QSI 004
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.0 lb
  - 8) TRIM D3650-11 TO FIT AS REQUIRED

DEO ATTACHED

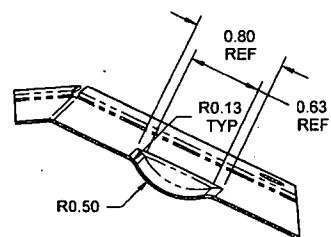
RELEASED  
08.11.17

UNDER REVIEW

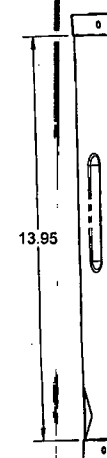
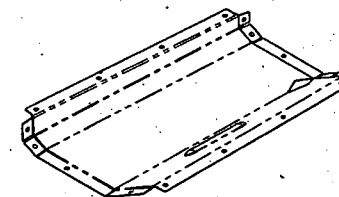
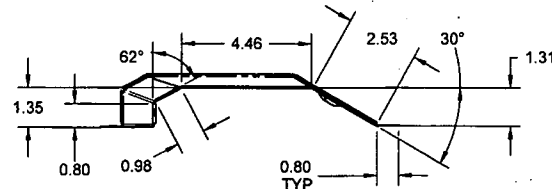
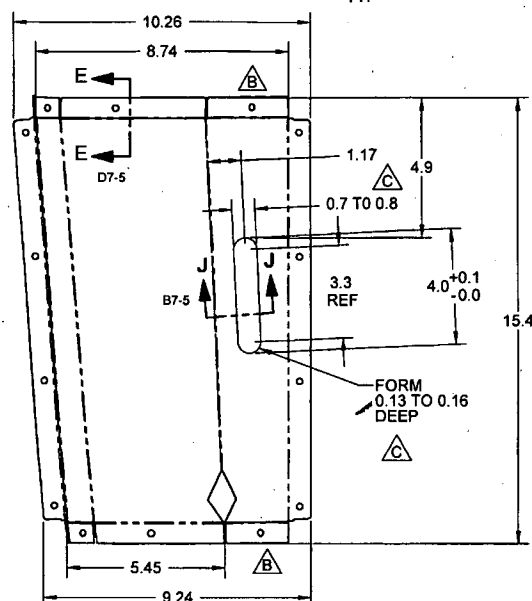
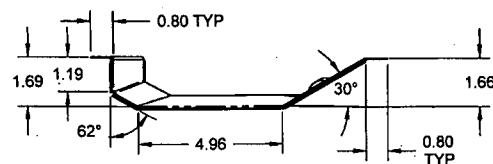
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING INTO THE HANDS OF ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**SECTION E-E** D5-5  
SCALE 2X



**SECTION J-J** C5-5  
SCALE 3.5X



- NOTES:  
1) FINISH: NONE  
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) UNITS: INCHES UNLESS OTHERWISE NOTED  
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
5) IDENTIFICATION: NONE

**D3650-3B CENTER PANEL BENT PART**  
(MAKE FROM D3650-3F FLAT PATTERN)

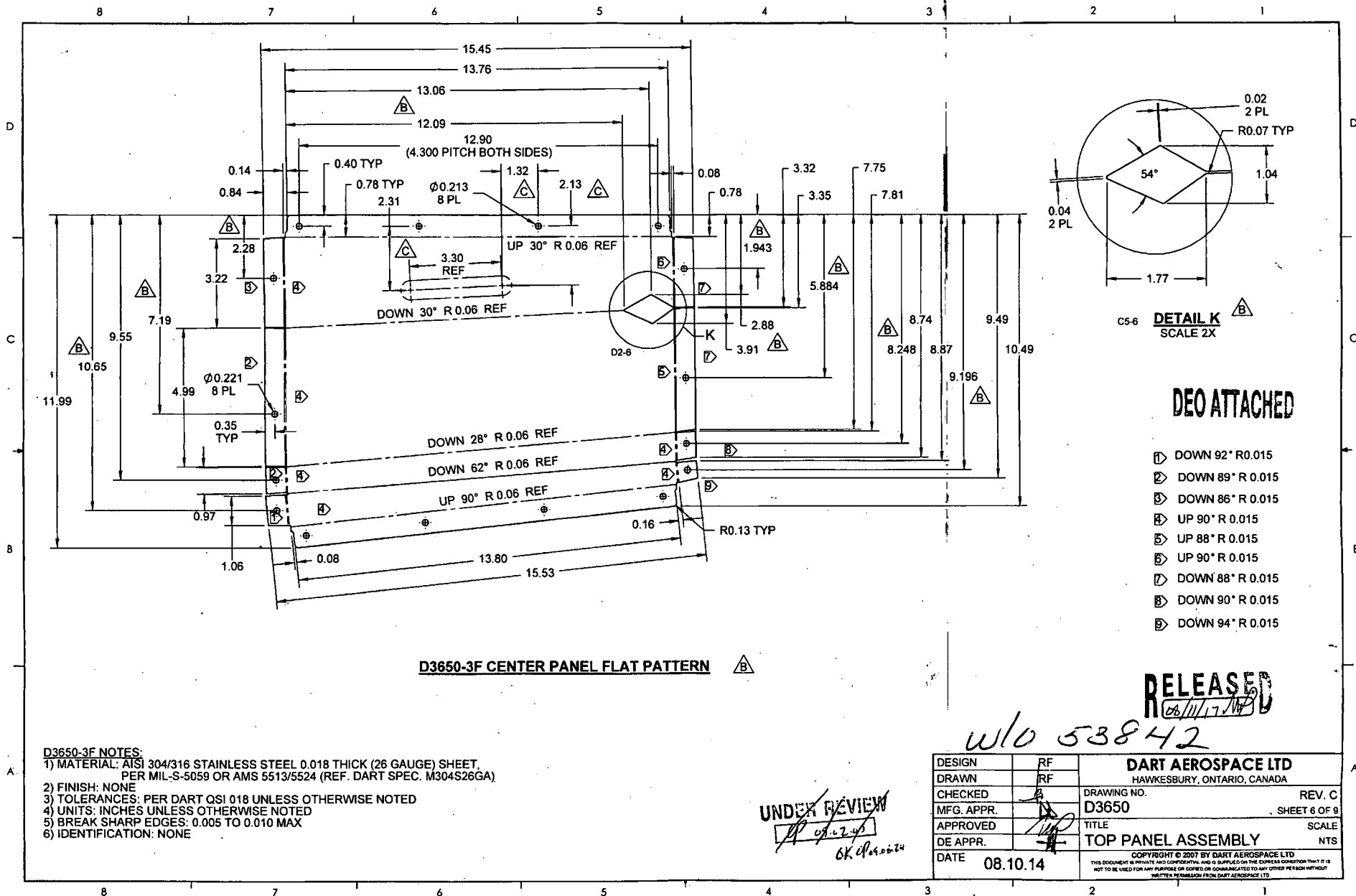
UNDER REVIEW

DEO ATTACHED

RELEASED  
08/10/14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			





MS21062-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL

MS21060-3K NUTPLATE  
MS20427M3-3 RIVET, 2 PL  
2 PL

D3650-5B  
FWD PANEL  
BENT PART  
REF

NAS1149CN432R  
WASHER, REF  
0.74  
0.07  
D3650-7-8.19 SEAL  
D3650-9 ANGLE

DETAIL F  
SCALE 3.5X

F  
D5-7

D3650-9 REF

D3650-5B  
FWD PANEL  
BENT PART

D3650-7-8.19  
REF

CENTRE D3650-7/-9 ON D3650-5B &  
TRANSFER Ø0.129 (#30 DRILL) HOLES  
FROM D3650-9 TO D3650-7 & D3650-5B  
AS SHOWN  
INSTALL  
MS20615-4M5 RIVET  
NAS1149CN432R WASHER  
12 PL

D3650-5 FWD PANEL

0.80  
TYP.  
1.35 0.84  
R0.06  
TYP.  
30°  
28°  
4.46  
1.05  
1.31

9.20  
8.35  
11.70

DEO ATTACHED

D3650-5B FWD PANEL BENT PART  
(MAKE FROM D3650-5F FLAT PATTERN)

RELEASED  
08/10/14

# PART LIST

QTY -S	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

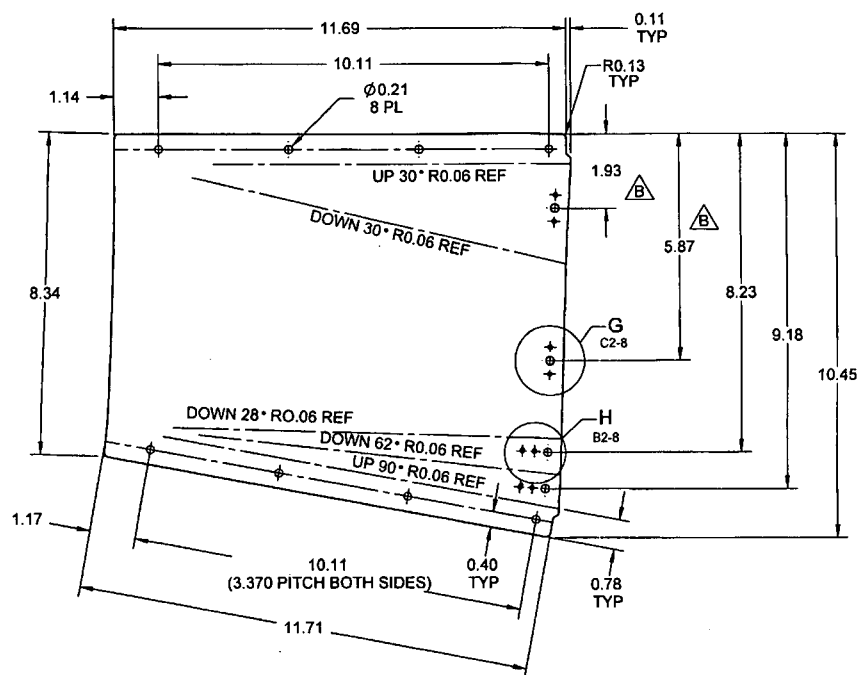
## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET.  
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

UNDER REVIEW  
08/10/14

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3650
APPROVED		TITLE
DE APPR.		TOP PANEL ASSEMBLY
DATE	08.10.14	SCALE
		NTS

COPYRIGHT © 2007 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

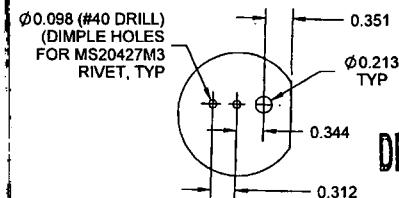
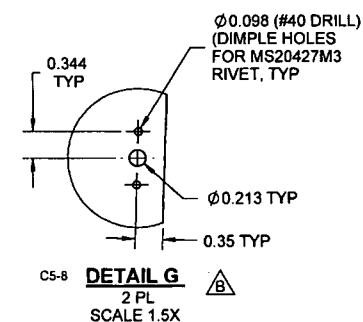
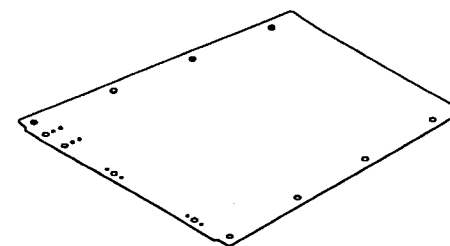


**D3650-5F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

**UNDER REVIEW**  
*Top 07.02.05*  
*OK 07.06.24*



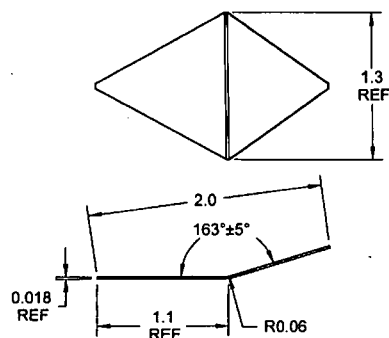
**DEO ATTACHED**

**DETAIL H**  
 2 PL  
 SCALE 1.5X

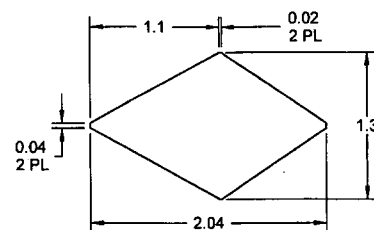
**RELEASED**  
*08/17/14*

*W/O 53842*

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3650</b>	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>TOP PANEL ASSEMBLY</b>	NTS
DATE	08.10.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



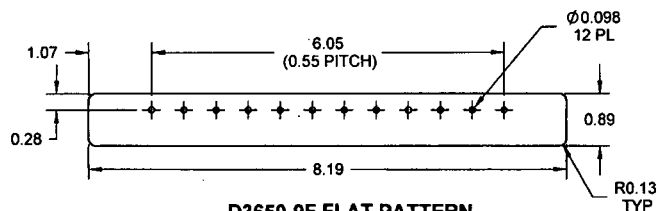
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)



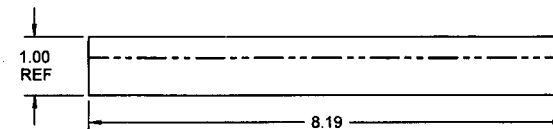
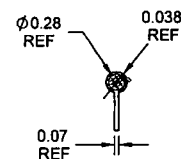
**D3650-11F FLAT PATTERN**



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-9F FLAT PATTERN**



**D3650-7-8.19 SEAL**

**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
- 8) D3650-11 WEIGHT: 0.007 lb



**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

DEO ATTACHED

RELEASED  
05/17/14

UNDER REVIEW  
01/07/08  
OK 01/07/08

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DRAWING NO. D3650	TITLE TOP PANEL ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3650-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 09.06.12	DATE 04.06.15	DATE 09.06.15	DATE 09/06/15	DATE 09/06/15			

W/O 53842

**TO AMEND D3650-5 FWD PANEL:**

REF PAR 09-008. THE QTY(12) NAS1149CN432R WASHERS ARE REPLACED WITH QTY(1) D3893-1 DOUBLER. THE QTY(12) MS20615-4M5 RIVETS ARE REPLACED WITH QTY(12) NAS9307M-4-03 RIVETS. LOCATION OF THE DOUBLER IS SHOWN IN THE AMENDED DETAIL F (DWG SHEET 7) BELOW. THE PARTS LIST FOR D3650-5 IS AMENDED AS FOLLOWS:

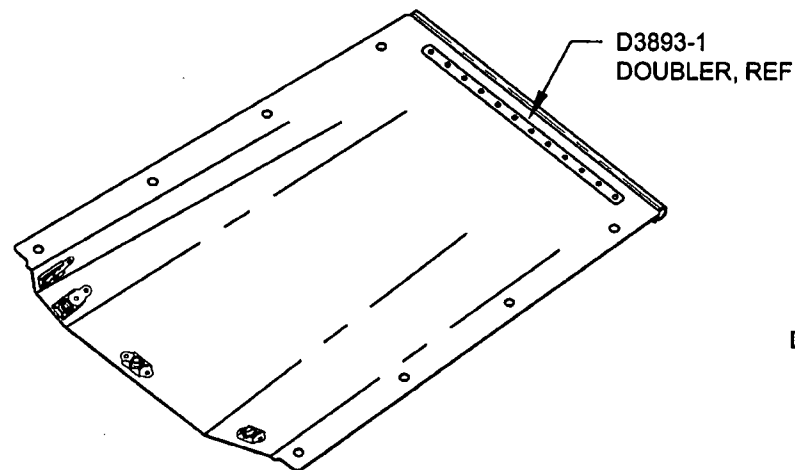
**IS:**

QTY	PART NUMBER	DESCRIPTION
-5		
1	D3893-1	DOUBLER
12	NAS9307M-4-03	RIVET (OR CR3523-4-03)

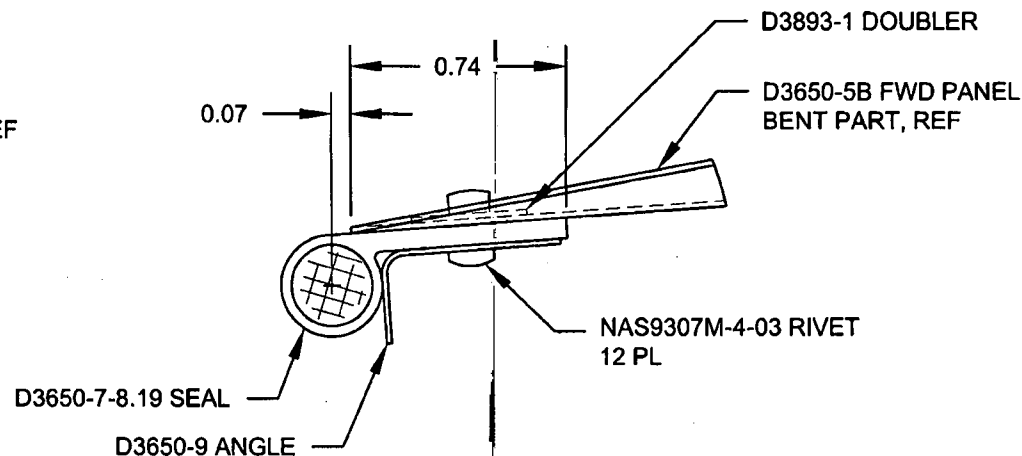
**WAS:**

QTY	PART NUMBER	DESCRIPTION
-5		
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET

**RELEASED**  
09/06/15



**D3650-5 FWD PANEL**



**DETAIL F** C5-7  
SCALE 3.5X